

Date: Tuesday, 9/12/2006 1:09:49 PM
 User: Kim Johnston

Process Sheet

43

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350/355 AS X-TUBE FWD
 Job Number : 28461
 Estimate Number : 12485
 P.O. Number : Part Number : D350748101
 This Issue : 9/12/2006 S.O. No. : Drawing Number : IIN-D350-748 PG5
 Prsht Rev. : NC Project Number : N/A
 First Issue : 11 Type : LANDING GEAR Drawing Revision : A UNDER REVIEW OK 06.09.13
 Previous Run : 28460 Material :
 Due Date : 10/25/2006 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 06.09.12
 Comment : Est Rev: A New Issue 06-07-05 JLM
 Est Rev: B Update qty of MS21042L5 06-09-12 KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD350-748-101 CHG001

2.0 28461A X-TUBE AS 350/355 HI FWD



Comment: Sub-Component X-TUBE AS 350/355 HI FWD

D350-748-141 B 28461A - 3/10/06

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 D35001 350 SADDLE



Comment: Qty.: 4.0000 Each(s) Unit Total: 4.0000 Each(s)

350 SADDLE

Batch: 1528477 ✓ 1528794 X

5.0 D35011 BUSHING



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

BUSHING

Batch: 1029799 X 7/7/12 SQ

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/12/2006 1:09:49 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE FWD

Job Number: 28461

Part Number: D350748101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Batch: M103962 ✓

7.0

AN441A

bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

bolt

Batch: M102552 ✓

8.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M103481 ✓

9.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

+2 Batch: M104215 ✓

10.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

+1 Batch: M103694 ✓

11.0

MS21042L4

Nut



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

+1 Batch: M102552 ✓

12.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M103830 ✓

7/1/12 SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/12/2006 1:09:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE FWD

Job Number: 28461

Part Number: D350748101

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

27/7/12 C 267071120

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-101

Location: B

PPP Rev: B

27/7/12

15.0

QC21

FINAL INSPECTION/W/O RELEASE

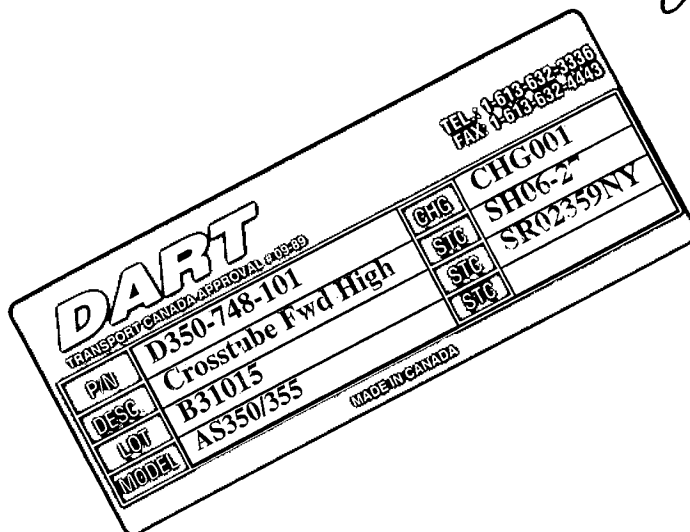


Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U.S. 812



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

3.10 Apply a continuous bead of Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class B2 sealant in the following locations as per Figure 6:

- A) Along saddle/crosstube interface.
- B) Between the saddle flanges.
- C) Along saddle/skidtube interface.

4.0 WEIGHT AND BALANCE

The following weight and balance information is for Dart crosstube installations only. This data should be similar to the existing installation. Differences from the parts removed are the responsibility of the installer.

DART CROSSTUBE	FWD/AFT	WEIGHT	STA	MOMENT
D350-748-101	Fwd	35.2 lb (16.0 kg)	106.3 in (2.70 m)	3742 lb-in (43.2 kg-m)
D350-748-201	Aft	34.7 lb (15.7 kg)	162.4 in (4.12 m)	5635 lb-in (64.7 kg-m)

5.0 PARTS LIST

Qty -101	Qty -201	Part Number	Description
X		D350-748-101	CROSSTUBE INSTALLATION, AS 350/355 HIGH FWD
	X	D350-748-201	CROSSTUBE INSTALLATION, AS 350/355 HIGH AFT
1		D350-748-141	CROSSTUBE ASSEMBLY, AS 350/355 HIGH FWD
	1	D350-748-241	CROSSTUBE ASSEMBLY, AS 350/355 HIGH AFT
*2	*2	D3502-1	SUPPORT
*2	*2	D2856-400-710	ABRASION STRIP
*1	*1	AELS-1032-225	INSERT
*2	*2	MS21920-20	CLAMP
*1	*1	MS27039-1-10	SCREW
*1	*1	AN960JD10	WASHER
4	4	D3500-1	SADDLE
16	16	D3501-1	BUSHING
16	16	AN4-6A	BOLT
8	8	AN4-41A	BOLT
4	4	AN5-32A	BOLT
32	32	AN960JD416	WASHER
8	8	AN960JD516	WASHER
24	24	MS21042L4	NUT (OR MS21042-4)
4	4	MS21042L5	NUT (OR MS21042-5)

* REFERENCE ONLY. PARTS ARE INCLUDED IN D350-748-141/241 ASSEMBLIES ABOVE

SHOP COPY
RETURN TO
ENGINEER

UNCONTROLLED

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER NO. 28461

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Revision: A
Date: 06.05.08

Date: Tuesday, 9/12/2006 1:09:49 PM
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Process Sheet

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Job Number	: 28461		
Estimate Number	: 12485		
P.O. Number	:	Part Number	: D350748101
This Issue	: 9/12/2006	S.O. No. :	Drawing Number : IIN-D350-748 PG5
Prsht Rev.	: NC		Project Number : N/A
First Issue	: / /	Type : LANDING GEAR	Drawing Revision : A UNDER REVIEW
Previous Run	: 28460		Material :
Written By	:	Due Date	: 10/25/2006 Qty: 1 Um: Each
Checked & Approved By	: <u>06 09.12</u>		
Comment	: Est Rev: A New Issue 06-07-05 JLM		
	: Est Rev: B Update qty of MS21042L5 06-09-12 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD350-748-101 CHG001

06 10 11 06

2.0	28461A	X-TUBE AS 350/355 HI FWD
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Comment: Sub-Component X-TUBE AS 350/355 HI FWD
D350-748-141 B _____

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

4.0	D35001	350 SADDLE
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
350 SADDLE
Batch: _____

5.0	D35011	BUSHING
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
BUSHING
Batch: _____

REFERENCE ONLY